

Work Order ID 56671

Page 1

March 4, 2010 11:19:19 AM

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 3/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							



Waterjet

FLOW CNC Waterjet

Memo

Cut as per Dwg

DWG REV: A

PROG REV: 4

DEBURR IF REQUIRED

RB 10-3-8

15

110

QC2- Inspect parts off machine FAI/FAIB



QC

Quality Control

0.00

Memo

0.00

RB 10-3-8

10

Pb >

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4064-041 PAR #: Fault Category: NCR: Yes No DQA: Date: 1004-08

Resolution: Disposition: QA: N/C Closed: Date: _____

NCR: 56671		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.03.30	130	PIN NOT ENGRAVED QC Parts were made on manually QSI 042	QP 10.03.30 PC QSI 042	Acceptable.	APR	<i>[Signature]</i>	<i>QP</i> 10.03.30 PC QSI 042	<i>S</i> 10.07.30

NOTE: Date & initial all entries

Work Order ID 56671

March 4, 2010 11:19:20 AM



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Item ID: D4064-041

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 3/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Mill Conv

Conventional Milling Machine

Operation
Description

Memo

MILL RADS,DRILL HOLES AS PER DWG
GRIND RAD .060"-.100" BY HANDSet Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

SL 10/03/11

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/03/11

Memo

0.00

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

JDF 10.03.11

Memo

0.00

(10)

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56671

March 4, 2010 11:19:20 AM



Page 3

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 3/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



HandFinish

Memo

Hand Finishing

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

13K

10-3-15

(D)

170



Powdercoat

Powder Coating

MU113170
 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
 START: 8:00AM
 Memo TEMP: 320°F
 FINISH: 8:30AM

0.00

=> MU
 10/03/30

(X10) ✓

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

S0103/30

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56671

March 4, 2010 11:19:21 AM



Page 4

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 3/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



HandFinish

Hand Finishing

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

0.00

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. 03/30

(10)

210



Packaging

Packaging

Identify as per dwg & Stock Location: ST464

0.00

Memo

0.00

CZ 10/3/31 10

Picklist Print

March 4, 2010 11:19:19 AM

Page 1

Work Order ID: 56671



Parent Item: D4064-041



Parent Item Name: Mounting Lug

Start Date: 3/04/10

Required Date: 3/12/10

Comments: IPP REV:A NEW ISSUE 10-03-01 JLM VERIFIED BY:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6B0.750X06.00
0

Purchased

No

100

f

63.5488

3.6842

5.6

6061T6 BAR .750 X 6.00



VB 10-3-0

MS35489-93

Purchased

No

190

Each

26.0000

20.0000



GROMMET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

{

MAT

63.5488

110912

3.5488

112567

60

112567

(K)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

{

ST

26

113368

26

113368/03/30

M114108

20X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56671
Description: MOUNTING LUG	Part Number:	D4064-D41
Inspection Dwg: D4064-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:	HB	JL
Date:	10-3-08	10/03/08

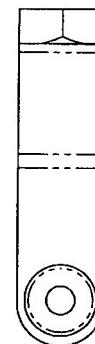
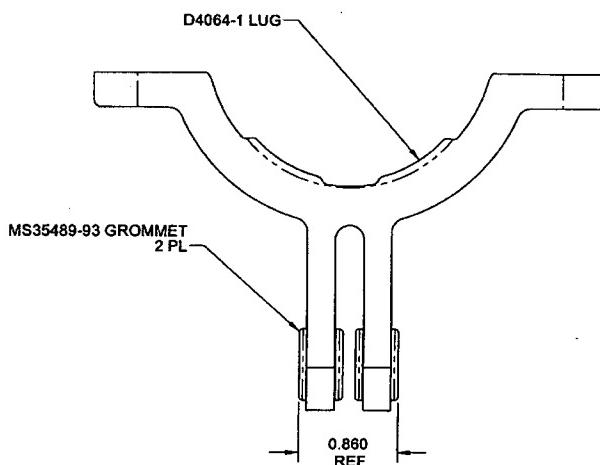
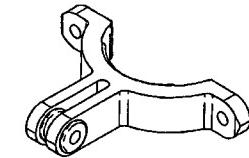
Audited by:	<i>J.J.</i>
Date:	10-03-11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY	P/N	DESCRIPTION
1	X	D4064-041	LUG ASSEMBLY
2	1	D4064-1	LUG
3	2	MS35489-93	GROMMET

0
56671



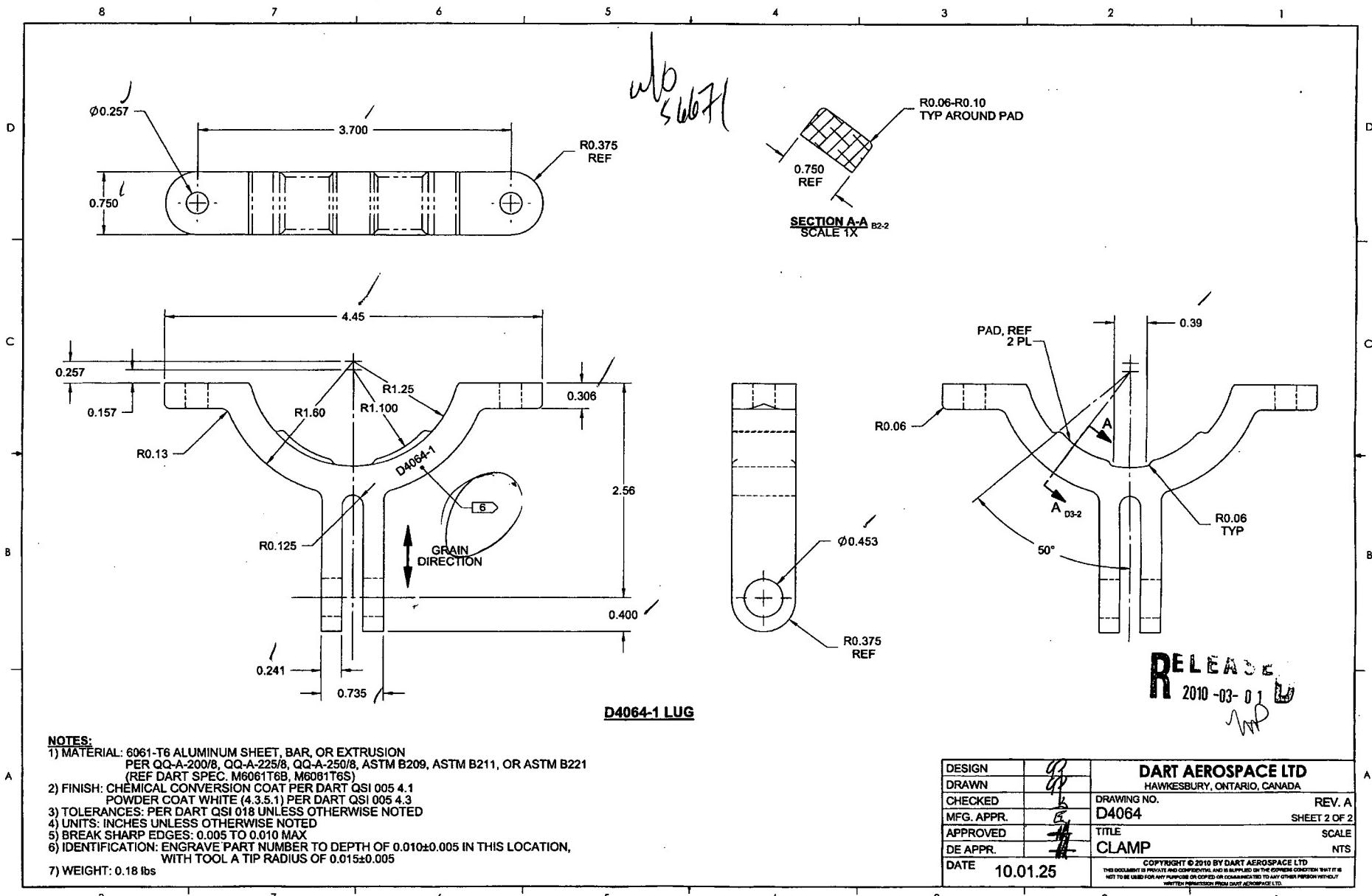
D4064-041 LUG

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.18 lbs

RELEASED
2010-03-01
W

A	NEW ISSUE	CP	10.01.25
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	99	DRAWING NO.	REV. A
CHECKED	99	D4064	SHEET 1 OF 2
MFG. APPR.	99	TITLE	SCALE
APPROVED	99	CLAMP	NTS
DE APPR.	99	DATE 10.01.25	

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



NOTES.

- NOTES:**

 - 1) MATERIAL: 6061-T6 ALUMINUM SHEET, BAR, OR EXTRUSION
PER QQ-A-200/8, QQ-A-225/8, QQ-A-250/8, ASTM B209, ASTM B211, OR ASTM B221
(REF DART SPEC. M6061T6B, M6061T6S)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010 ± 0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015 ± 0.005
 - 7) WEIGHT: 0.18 lbs

DESIGN	<i>99</i>	DART AEROSPACE LTD	
DRAWN	<i>99</i>	HAWKSBURY, ONTARIO, CANADA	
CHECKED	<i>3</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>E</i>	D4064	SHEET 2 OF 2
APPROVED	<i>1</i>	TITLE	SCALE
DE APPR.	<i>1</i>	CLAMP	NTS
DATE	10.01.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE PROPERTY OF DART AEROSPACE LTD. AND IS BOUND BY THE ECONOMIC DISPOSITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	